

SPLIT

SPLIT SB 07/10/11

Date: Monday, 9/10/2007 1:19:09 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 34478	
Estimate Number : 12811	
P.O. Number : N/A	Part Number : D35921
This Issue : 9/10/2007 S.O. No. : N/A	Drawing Number : D3592 REV.B
Prsht Rev. : NO	Project Number : N/A
First Issue : N/A	Drawing Revision : B
Previous Run : 34260	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 9/17/2007
Checked & Approved By : <u>[Signature] 07.09.10</u>	Qty: 48 Um: Each
Comment : Est Rev: A New Issue 07-03.26 ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S125	6061-T6 .125 Sheet
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Comment: Qty.: 0.1460 sf(s)/Unit Total : 7.0056 sf(s)
6061-T6 .125 Sheet

Batch: M104480 107-10-11

Grain must be Along 4.63"** GRAIN AT 45°, SEE DWG (P. 10-11)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg D3592
Dwg Rev: B
Prog Rev: B

107-10-11

2-Deburr if necessary 107-10-11

(56)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

107-10-11

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

En 07/10/11

counter
(56)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Bend 3-5 only

PTD

Form as per Dwg D3592 using DT8949

SB 07/10/23

(54)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/10/11	5	Split W/O	SB	07/10/11	54		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/10/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 9/10/2007 1:19:09 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 34478

Part Number: D35921

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

counter
8/10/23 (x54)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WH29

8/10/25 54

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(51)
8/10/26

Job Completion



8/10/25

POSITIVE RECALL

EFFECTIVE 07/09/10 AUTH 4

RELEASED 07/10/09 DATE 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

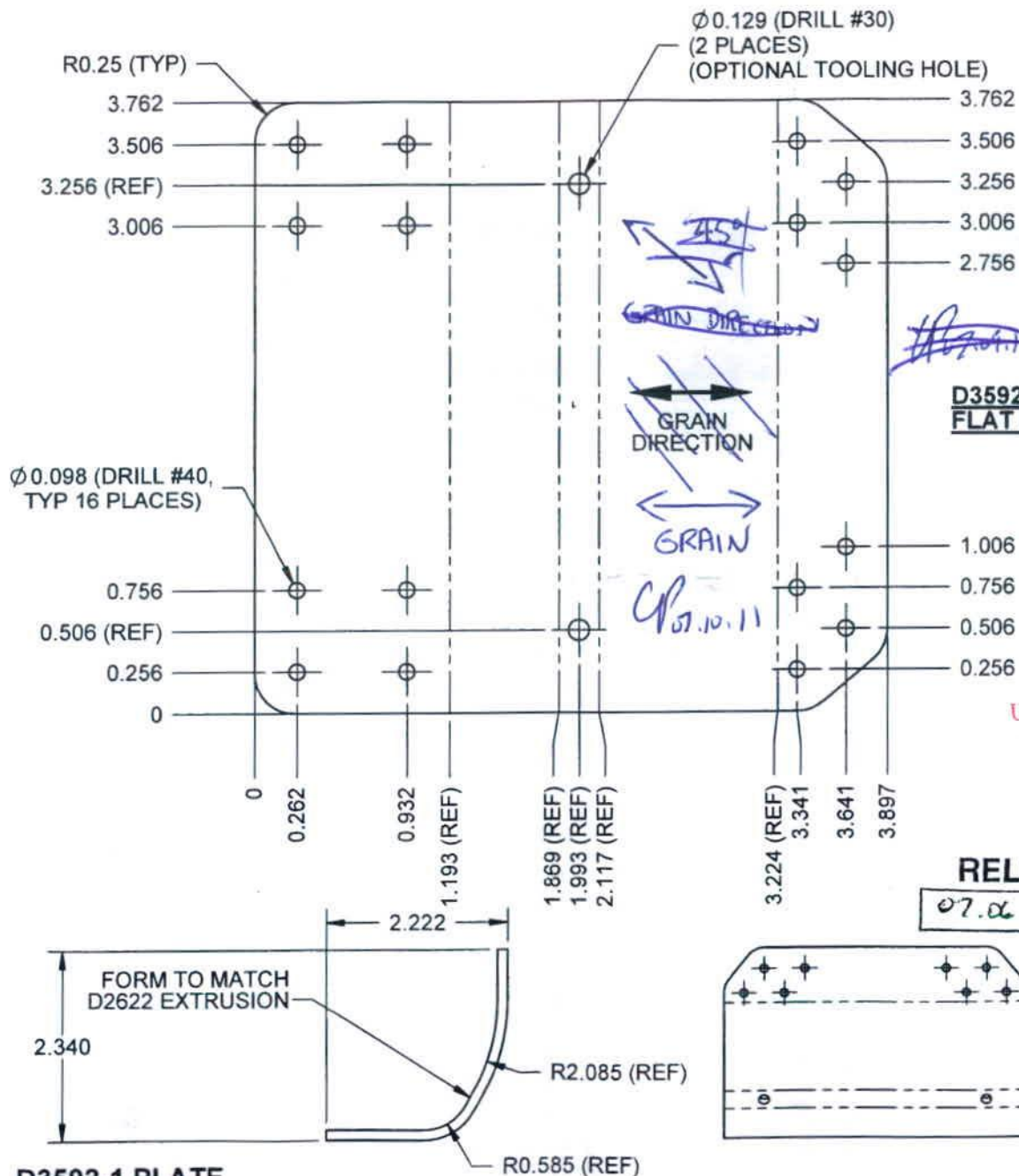
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN QP	DRAWN BY JC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED QP	APPROVED [Signature]	DRAWING NO. D3592	REV. B SHEET 1 OF 1
DATE 07.05.31		TITLE PLATE	SCALE 1:1
A	07.01.15	NEW ISSUE	
B	07.05.31	TOOLING HOLES ADDED	

**D3592-1F
FLAT PATTERN**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED CO
SUBJECT TO AMENDME
WITHOUT NOTICE
WORK ORDER
NO. 34478

RELEASED

07.05.31 [Signature]

**BEND DETAIL
SCALE 1:2****D3592-1 PLATE****NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.125" THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.125)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.010 MAX

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DART AEROSPACE LTD		Work Order: 34478
Description: BRACKET		Part Number: 03592-1
Inspection Dwg: 3592	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .129	+ .004 - .001	.130	X			
Ø .098	+ .005 - .001	.099	X			
.256	+/- .010	.256	X			
.506	+/- .010	.506	X			
.756	+/- .010	.756	X			
3.006	+/- .010	3.006	X			
3.256	+/- .010	3.256	X			
3.506	+/- .010	3.506	X			
3.762	+/- .010	3.762	X			
2.756	+/- .010	2.756	X			
1.006	+/- .010	1.006	X			
.262	+/- .010	.262	X			
.932	+/- .010	.932	X			
1.193	+/- .010	1.193	X			
R.25 + .004	+/- .030	.25	X			
1.993	+/- .010	1.993	X			
2.117						
3.341	+/- .010	3.341	X			
3.641	+/- .010	3.641	X			
3.891	+/- .010	3.900	X			
.125	+/- .010	.122	X			

Measured by: WB	Audited by: [Signature]	Prototype Approval:
Date: 07-10-11	Date: 07/10/11	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

[Signature]

